

Date: Monday, 12/01/2009 9:12:15 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT DOUBLER
Job Number	: 44596		
Estimate Number	: 13277		
P.O. Number	:	Part Number	: D37033
This Issue	: 12/01/2009 S.O. No. :	Drawing Number	: D3703 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: PRELIM
Previous Run	: 38946	Material	:
Written By	:	Due Date	: 15/01/2009
Checked & Approved By	:	Qty:	5 Um: Each
Comment	: Est Rev:A 08-04-24 new issue DD verified by:EC		



Additional Product

Job Number:



PRELIMINARY ISSUE
 09.01.14. P22 ECN # 09.502 P

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 1.1666 sf(s)/Unit Total : 5.8328 sf(s)
 6061T6 aluminium sheet .063" thick
 (M6061T6S063)
 Batch: 108279 IB 9-1-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3703
 Dwg Rev: PRE IB 9-1-13
 Prog Rev: LIM

2- Deburr if necessary IB 9-1-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING APPROVAL
 09.01.15 18 09.01.13

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

09.01.14 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 9:12:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOUBLER

Job Number: 44596

Part Number: D37033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-11

(K6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Q215.



(B)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 138

9/6/08

SY

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09/01/12 AUTH L

RELEASED 09/06/08 DATE 09.06.05

WF 09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

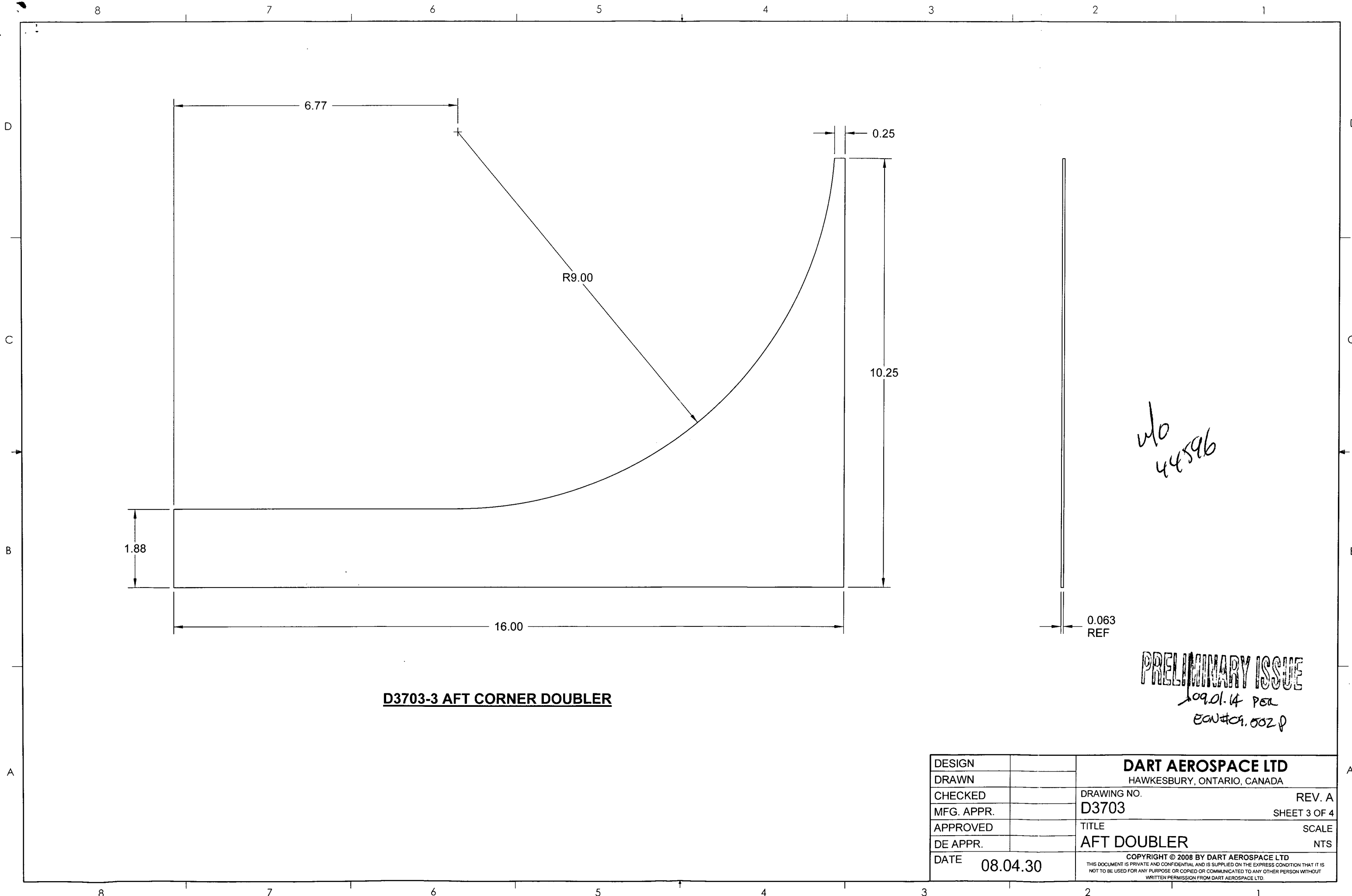
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

X

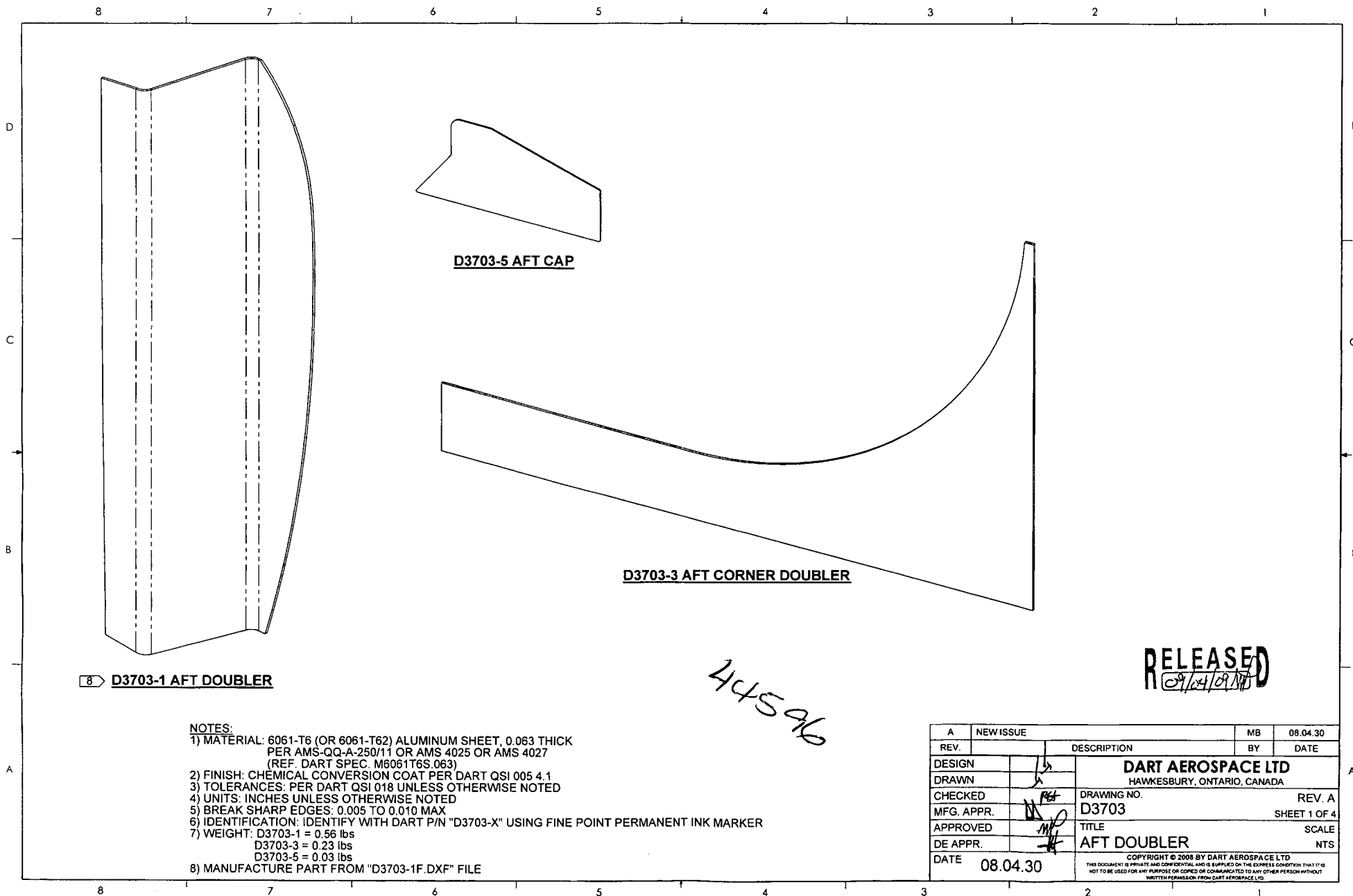
X



D3703-3 AFT CORNER DOUBLER

PRELIMINARY ISSUE
09.01.14 per
EON#09.002P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 D3703-1 AFT DOUBLER

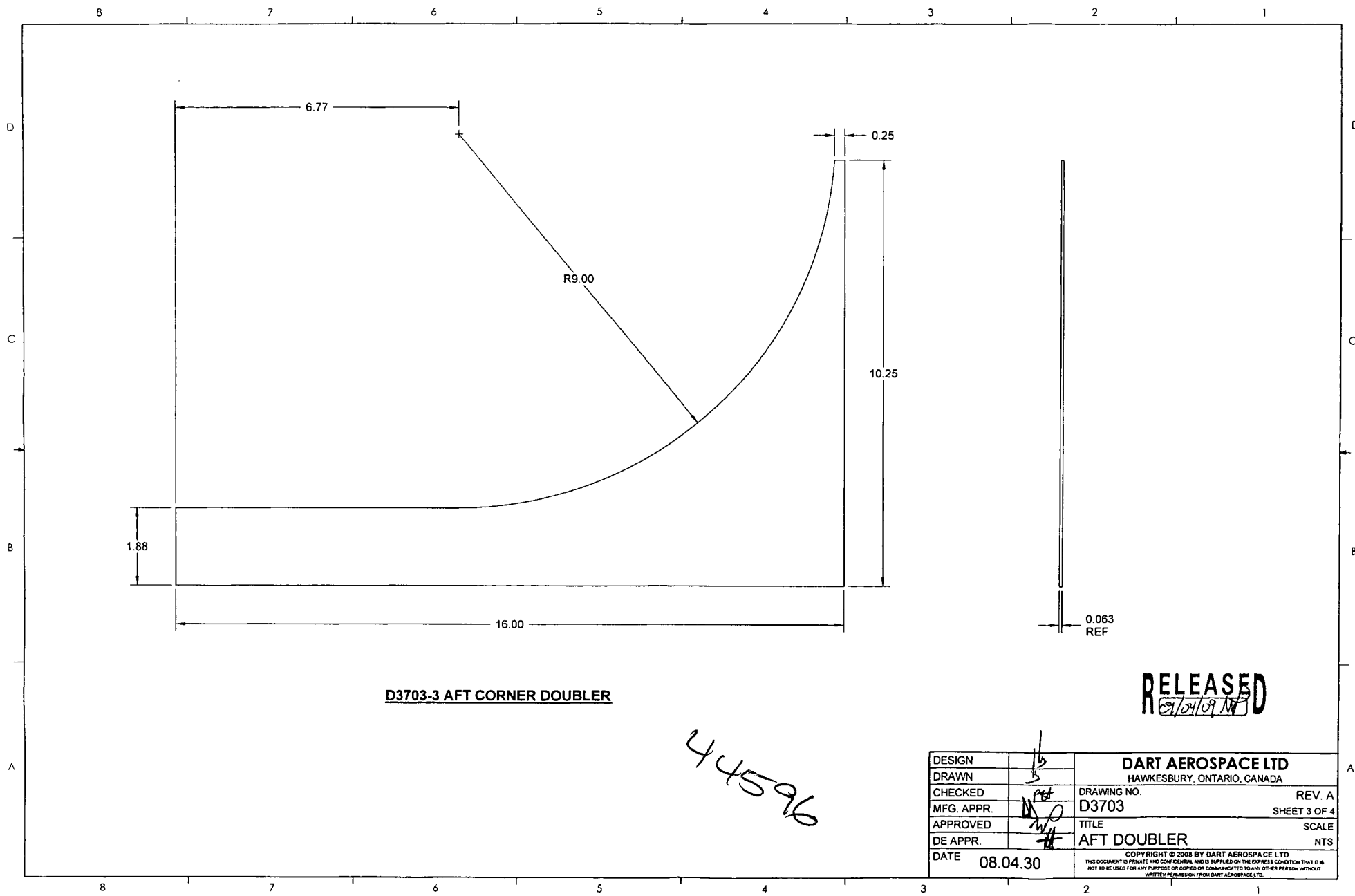
D3703-5 AFT CAP

D3703-3 AFT CORNER DOUBLER

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
 - 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.30		

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D3703-3 AFT CORNER DOUBLER

RELEASED
9/24/97

44596

DESIGN		DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO.	REV. A
MFG. APPR.	W/P	D3703	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
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